

# Work Order ID 72442

Friday, August 05, 2011 9:11:27 AM

Page 1

Item ID: D4005-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Rear Restraint Angle Gutter

Start Date: 7/25/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan: U

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4005

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

AS 11/08/05

AS

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

AS 11/08/05

AS

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Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

135

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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164

0.00



Small Fab

Memo

0.00

Small Fab

1-Install abrasion strip and trim excess as per dwg

BT 11-08-05

166

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. Mosler

(P)

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

C. G. 08

**Work Order ID 72442**

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Item ID: D4005-1

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Setup Start



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Stop



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Start Date: 7/25/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140	Chemical Conversion Coat per QSI005 4.1	0.00							
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HandFinish

Memo

0.00

Hand Finishing

5 6 11.08.05

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
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Powdercoat

Memo

0.00

Powder Coating

Start Time: 1:00  
Oven Temperature: 320°F  
Finish Time: 1:20

5 11.08.05

160	QC3- Inspect Part Finish	0.00							
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QC

Memo

0.00

Quality Control

5 11.08.05

5

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

OK 8/5/11

11-08-5  
5

# Picklist Print

Friday, August 05, 2011 9:11:24 AM

Page 1

Work Order ID: 72442

Parent Item: D4005-1

Parent Item Name: Rear Restraint Angle Gutter



Start Date: 7/25/2011

Required Date: 8/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.01.21 new issue Prelim EC verified by:DD IPP Rev:B  
10.05.03 as per ECN10-562 DD verified by:EC IPP Rev:C 10.11.11  
added abrasion strip DD verified by:E

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2856-100-1100  Abrasion Strip cut one at 11.00"		Manufactured	No			164	Each	0.0000	1	2			
M2024T3S.063  2024-T3 .063 sheet		Purchased	No			100	sf	247.3800	0.1451	0.305474			

Location

Loc Qty

Loc Code

MAT022

247.38

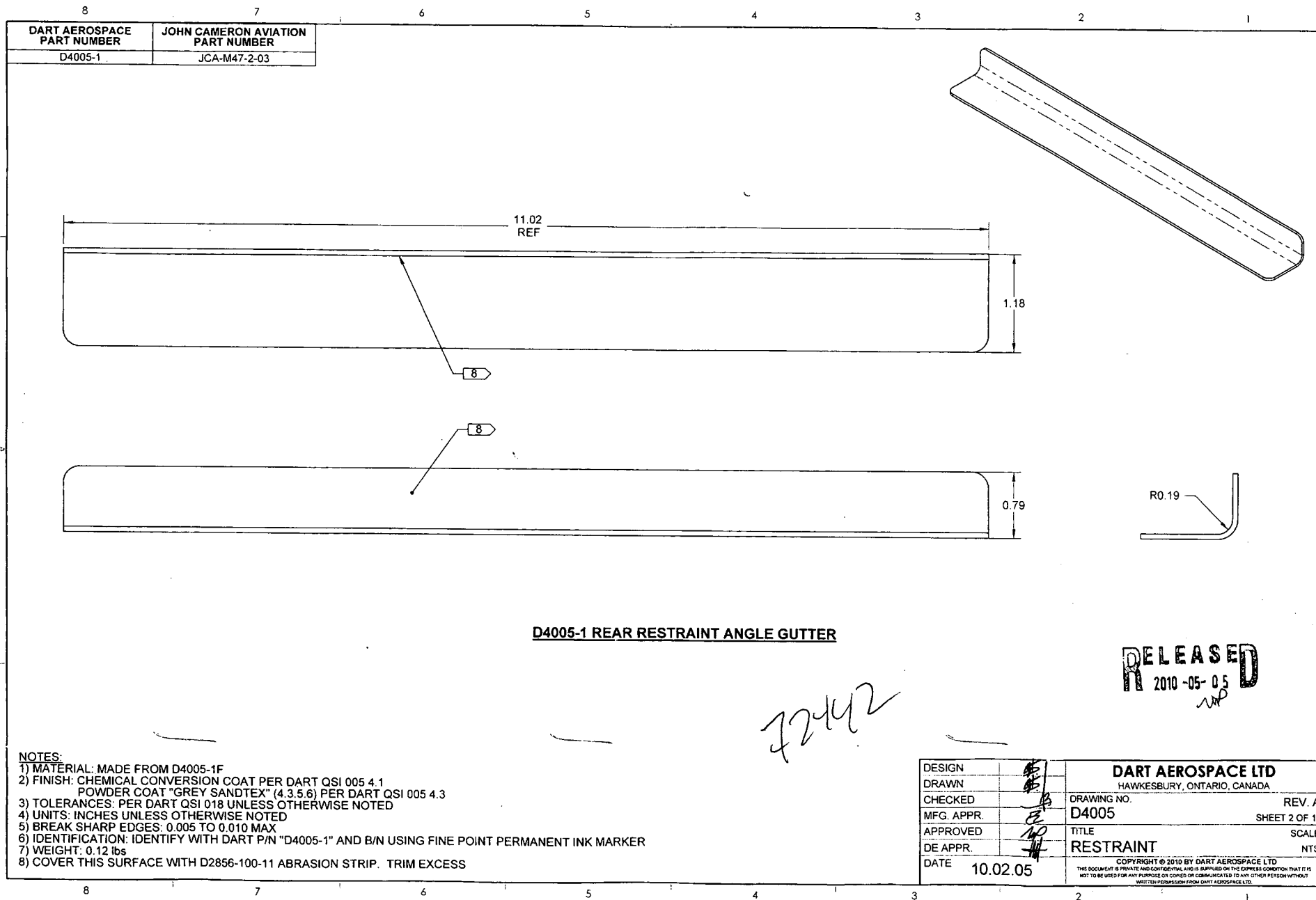
117018

25.88

117392

221.5

5. ~~AD~~ 11/08/05



8 7 6 5 4 3 2 1

D

C

B

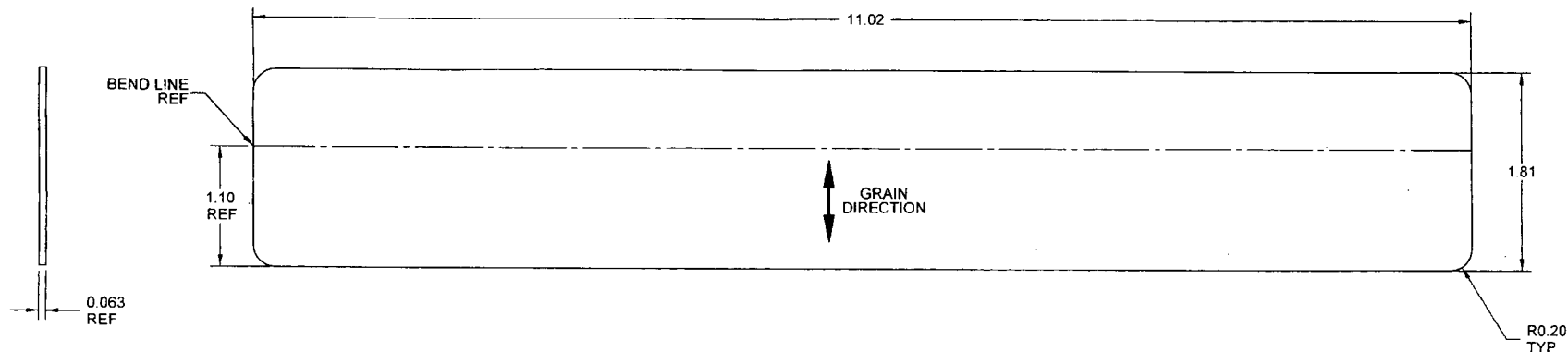
A

D

C

B

A



**D4005-1F FLAT PATTERN**

*72442*

**RELEASED**  
2010-05-05  
*MP*

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	<b>D4005</b>	SHEET 3 OF 15
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	<b>RESTRAINT</b>	NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1





DART AEROSPACE LTD		Work Order:	72442
Description: ANGLE GUTTER		Part Number:	4005-1
Inspection Dwg: 4005, Rev: A		Page 1 of 1	

# FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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[illegible]

Measured by:		Audited by:		Prototype Approval:	
Date:	11/08/05	Date:	11/08/05	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	